

Date: Wednesday, 19/11/2008 2:18:41 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DUAL HIGH BACK SEAT
Job Number	: 43557		
Estimate Number	: 12271		
P.O. Number	:	Part Number	: D350689041
This Issue	: 19/11/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: IIN-D350-689 PG9
First Issue	: / /	Project Number	: N/A
Previous Run	: 43345	Drawing Revision	: A
		Material	:
Written By	:	Due Date	: 28/11/2008
		Qty:	1 Um: Each
Checked & Approved By	: <u>JUL 08.11.19</u>		
Comment	: Est Rev:H Removed Sub-Parts 06-02-09 JLM		
	: Est Rev:I As per NCR 070 06-09-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D30231	Back Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1	D3023-1	Back Panel	<u>B44564</u>
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EL 9-2-85

2.0	D3017041	Back Frame Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1	D3017-041	Back Assembly	<u>B43601</u>
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EL 9-2-85

3.0	MS20600AD4W2	Rivet
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Comment: Qty.: 40.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number Description Batch

40	ms20600ad4w2	Rivet	<u>M106513</u> (34)
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M110267 (37)

EL 9-2-85

4.0	MS20600AD4W3	Cherry Rivets
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Cherry Rivets

Batch: M104715

EL 9-2-85

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DUAL HIGH BACK SEAT

Job Number: 43557

Part Number: D350689041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble as per IIN 350-689-041

EP 09/02/26 @ FL 9-775

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sort 02/26 @

Sort 02/26

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: *7:15am*

OVEN TEMPERATURE: *320°F*

FINISH TIME: *7:45am*

HL 09-02-27 (X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/02/27 (P)

9.0

D30241

Spacer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 D3024-1 Spacer *B43394*

EP 09/03/02

10.0

D30281

Stud



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3028-1 Stud *B33369 (2x)*

B42448 (2x)

B302

EP 09/03/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: DUAL HIGH BACK SEAT

Job Number: 43557

Part Number: D350689041

Job Number:



Seq. #: Machine Or Operation: Description :

11.0 D30291 Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3029-1 Spring 642447

CP09/03/02

12.0 D30301 Lock



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3030-1 Lock 634311

CP09/03/02

13.0 D30311 Loop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3031-1 Loop 627949

*

CP09/03/02

14.0 AN312A Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch
3 AN3-12A Bolt M109297

CP09/03/02

15.0 AN960JD10L Washer



Comment: Qty.: 23.0000 Each(s)/Unit Total : 23.0000 Each(s)

Pick:

Qty Part Number Description Batch
23 AN960JD10L Washer M109632

CP09/03/02

16.0 MS21042L3 Nut



Comment: Qty.: 23.0000 Each(s)/Unit Total : 23.0000 Each(s)

Pick:

Qty Part Number Description Batch
23 MS21042L3 Nut (or -3) M110399

CP09/03/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 43557

Part Number: D350689041

Job Number:



Seq. #: Machine Or Operation: Description :

17.0 MS24693S272 Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS24693-S272 Screw M110123

EP09/13/02

18.0 MS27039117 Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS27039-1-17 Screw M11540

EP09/13/02

19.0 MS27039119 Screw



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS27039-1-19 Screw M110089

EP09/13/02

20.0 D30221 Seat Pan



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D3022-1 Seat Pan

Batch
B44563

EL 9-2-25

21.0 D3021041 Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D3021-041 Tube Assembly

Batch
B43608

EL 9-2-25

22.0 D3016041 Seat Frame Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D3016-041

Frame Assembly

Batch
B43600

EL 9-2-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 43557

Part Number: D350689041

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble as per Dwg IIN-D350-689

24.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. DSI 9349	REV. A SHEET 1 OF 1
DATE 06.08.16		TITLE RIVET CHANGE	SCALE NTS
A	06.08.16	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-689 Rev.A
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-689 Rev.0
REF. CANADIAN STC: SH02-33
REF. FAA STC: SR01620NY

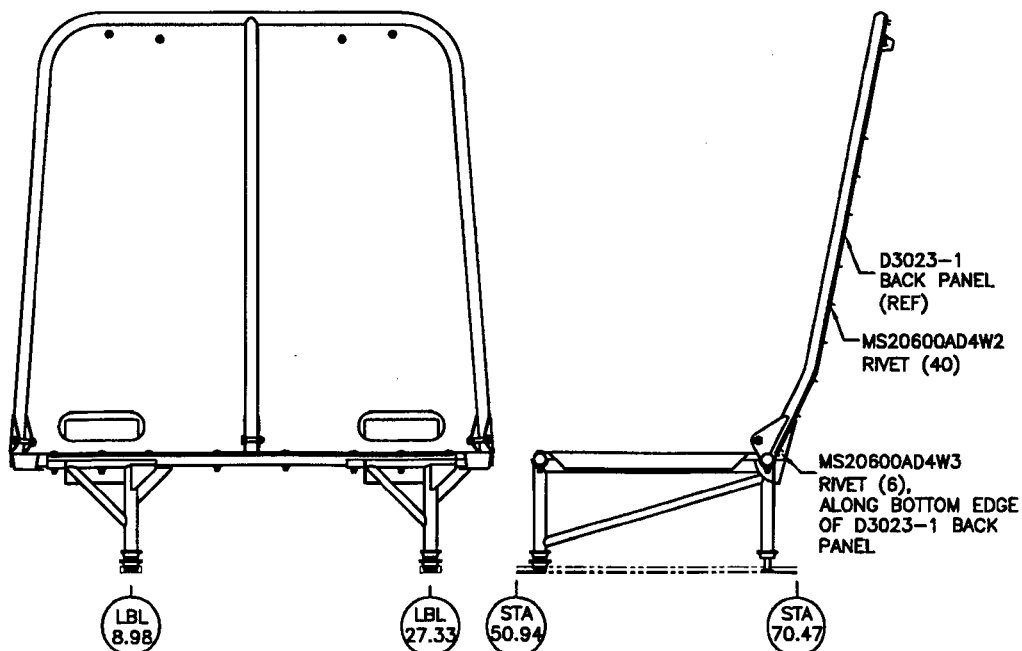
Some rivet lengths have changed, as indicated below, to ensure proper assembly of the D350-689-041 Dual High Back Seat Assembly. If installing replacement parts, it is acceptable to use longer rivets in other locations as required to ensure proper fastening. The parts list is revised as follows:

WAS:

QTY -041	Part Number	Description
X	D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
46	MS20600AD4W2	RIVET

NOW:

QTY -041	Part Number	Description
X	D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
40	MS20600AD4W2	RIVET
6	MS20600AD4W3	RIVET



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43557

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 06.08.16
CERT. NO.: SH02-33
ISSUE NO.: 1

D350-689-041 Dual High Back Seat Assembly

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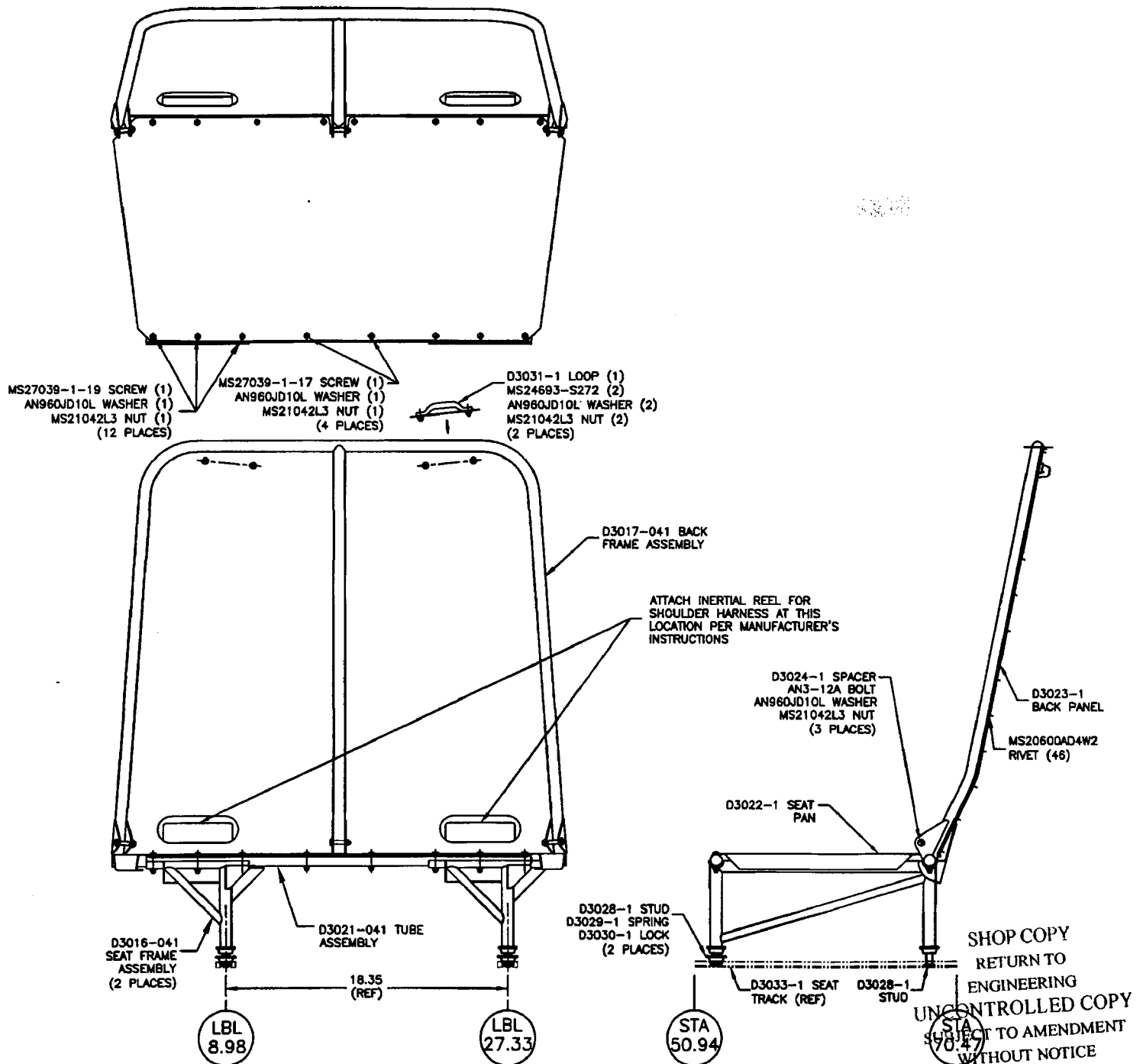


FIGURE 6: Installation of D350-689-041 Dual High Back Seat Assembly

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Revision: A
Date: 01.05.30